

## Claims

1. Tool head for employment in machine tools with a base body (12), a tool shank (14) projecting axially beyond the base body (12) and adapted for being coupled to a rotating machine spindle, and at least two blade receptacles (18, 18', 18'') which are spaced apart at least in the circumferential direction for receiving respectively one indexable cutting insert (20, 20', 20''), of which the active main cutting edge exhibits differing adjustment angles ( $\alpha$ ,  $\alpha'$ ,  $\alpha''$ ) relative to the base body axis, thereby characterized, that the same type of indexable cutting inserts (20, 20', 20'') are provided in the different blade receptacles (18, 18', 18''), and that the active main cutting edges (34) of the indexable cutting inserts (20, 20', 20'') along their length are subdivided into at least two blade segments (36, 36', 36'') in alignment with each other, wherein for each of the various blade receptacles (18, 18', 18'') respectively only one of the cutting segments (36, 36', 36'') the indexable cutting inserts is effective with the associated adjustment angle ( $\alpha$ ,  $\alpha'$ ,  $\alpha''$ ).
2. Tool head according to Claim 1, thereby characterized, that the effective cutting blade segment (36, 36', 36'') of the indexable cutting inserts (20, 20', 20'') exhibit an axial separation from each other in the various insert receptacles (18, 18', 18'').
3. Tool head according to Claim 1 or 2, thereby characterized, that the indexable cutting inserts (20, 20', 20'') exhibit at least three main blade segments (34, 34', 34''), of which in the clamped-in condition respectively only one (34) is active with its effective cutting blade segment (36, 36', 36'').

4. Tool according to one of Claims 1 through 3, thereby characterized, that the blade receptacles (18, 18', 18'') include short clamp holders (16, 16', 16'') for the indexable cutting inserts (20, 20', 20''), which are rigidly connected with the base body (12).
5. Change-out cutting head according to one of Claims 1 through 4, thereby characterized, that in addition a reamer (22) is provided centrally projecting in the direction of advance beyond the area of the indexable cutting inserts (20, 20', 20'').
6. Tool head according to Claim 5, thereby characterized, that the reamer (22) is displaceable axially relative to the base body (12).
7. Indexable cutting insert for tool heads (10) for employment in machine tools, with a multi-sided circumference, with main cutting edges (34, 34', 34'') on the individual circumference edges, of which in the operating condition respectively one (34) is active with a predetermined adjustment angle ( $\alpha$ ,  $\alpha'$ ,  $\alpha''$ ), thereby characterized, that the active main cutting edges (34) are subdivided along their length into at least two cutting segments (36, 36', 36'') aligned with each other, of which in the operating condition respectively only one is effective with a predetermined adjustment angle ( $\alpha$ ,  $\alpha'$ ,  $\alpha''$ ).
8. Indexable cutting insert accordingly to Claim 7, characterized by an imprint (3, 4, 6) provided in the area of the main blade edge (34, 34', 34'') marking the individual cutting segments (36, 36', 36'').